

Date: Tuesday, 8/22/2006 4:08:44 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BASKET BASE ASSEMBLY (350)		
Job Number	28291C	Part Number	D2221		
Estimate Number	10189	Drawing Number	D2221/D2235		
P.O. Number	N/A	Project Number	N/A		
This Issue	8/22/2006	S.O. No.	N/A		
Prsht Rev.	NC	Type	LARGE FAB ASSY		
First Issue	N/A				
Previous Run	28140C	Material	N/A		
Written By		Due Date	8/29/2006	Qty:	1 Um: Each
Checked & Approved By	<i>[Signature]</i> 06 08 23				
Comment	Est Rev:J 05/09/02 Added D3442-1KJ/JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	D31661	Basket Hoop			
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)					
Pick: Qty Part Number Description Batch					
4	D3166-1	RIB	<i>B23094</i>	<i>PD</i>	<i>06-09-12</i>
2.0	D22323	Basket Hinge			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)					
Pick: Qty Part Number Description Batch					
2	D2232-3	Hinge bracket	<i>B24527</i>	<i>PD</i>	<i>06-09-12</i>
3.0	D2325	Support Gusset (350 Bask)			
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)					
Pick: Qty Part Number Description Batch					
4	D2325	Support Gusset	<i>B27582</i>	<i>PD</i>	<i>06-09-12</i>
4.0	D23273	Spacer Bushing			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)					
Pick: Qty Part Number Description Batch					
2	D2327-3	Bushing	<i>B27051</i>	<i>PD</i>	<i>06-09-12</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 8/22/2006 4:08:45 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 28291C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	B27581

PD

06-09-12

(1)

6.0 D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3442-1	Shim	B26739

PD

06-09-12

(1)

7.0 M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty	Part Number	Description	Batch
36 sf	M304EX0.75-16F	Expanded Metal	H10200L

PD

06-09-15

(1)

8.0 M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28'	3/4" x 3/4" x 0.063 wall	304/316 SStubing
Batch:	H101937	

PD

06-09-11

(1)

9.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

PD

06-09-20

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06/09/ 26.		Applied Sikaflex <del>before</del> <sup>after</sup> placing rivets B m 101855 Exp - 02/2007	MF.	06/09/ 26.			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes  No DQA: LSDate: 06/09/27

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Tuesday, 8/22/2006 4:08:45 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 28291C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

10/06/09/22 ①

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Am 06-09-23 ①

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 06-09-26 ②

13.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

③ 06/09/27

Job Completion



6 06-09-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



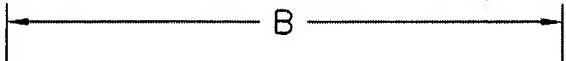
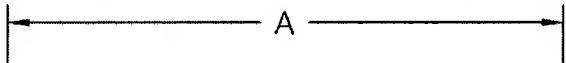
DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
	C 95.11.21	SEPARATE BASKET AND LID	
	D 96.06.21	CHANGE LATCH	
	E 01.04.19	CHANGE HINGE	
	F 05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

RELEASED

05.08.19 *[initials]*

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28291



45°

D2221-1/-3/-5/-7

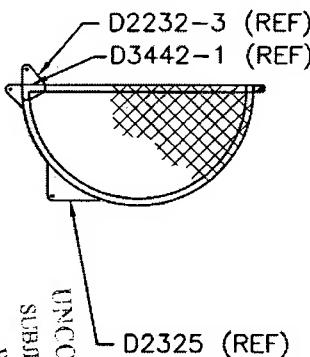
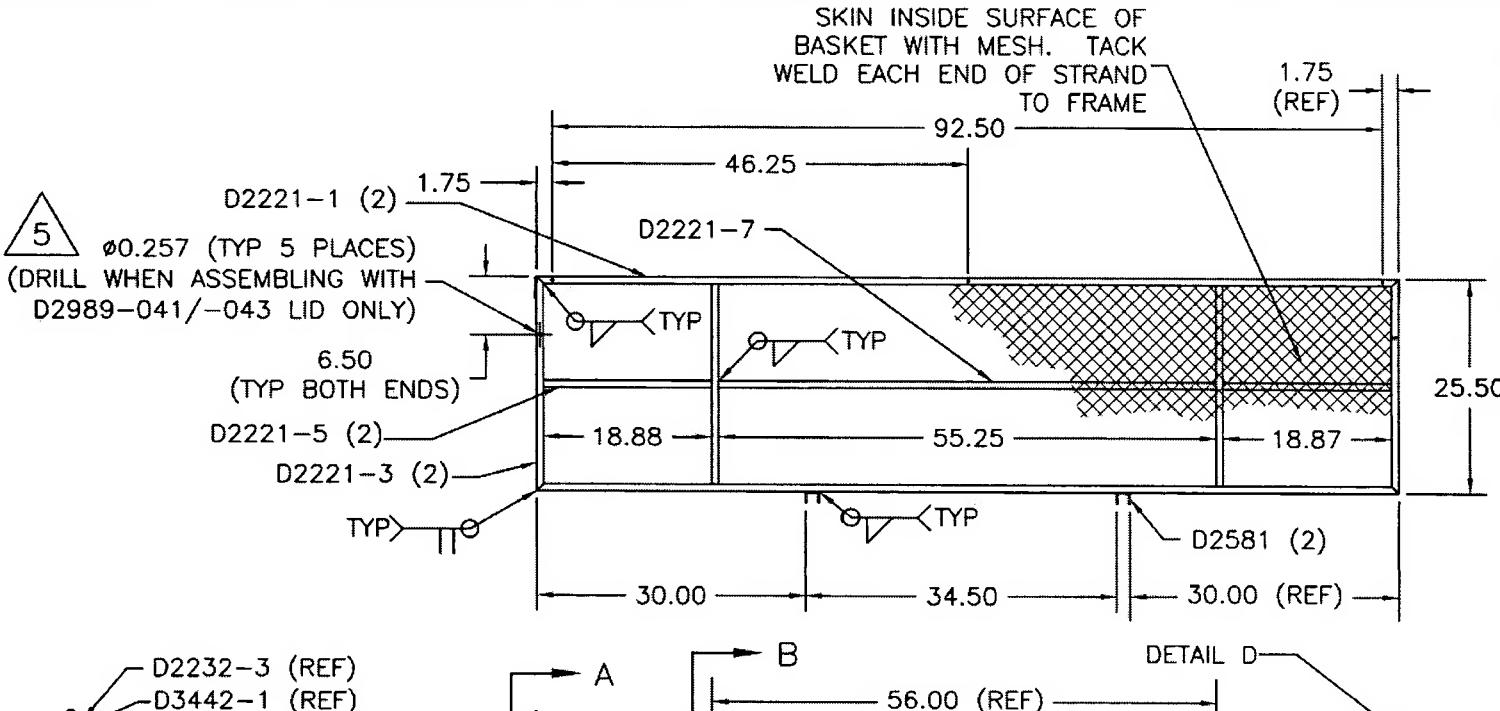
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING  
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH  
D2989-041/-043 BASKET LID

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**DART**

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D2221	HAWKESBURY, ONTARIO, CANADA
DATE 05.06.07	TITLE	REV. F	
		BASKET BASE ASSEMBLY (350)	SHEET 2 OF 3 SCALE 1:20



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 2022-1C

**RELEASED**

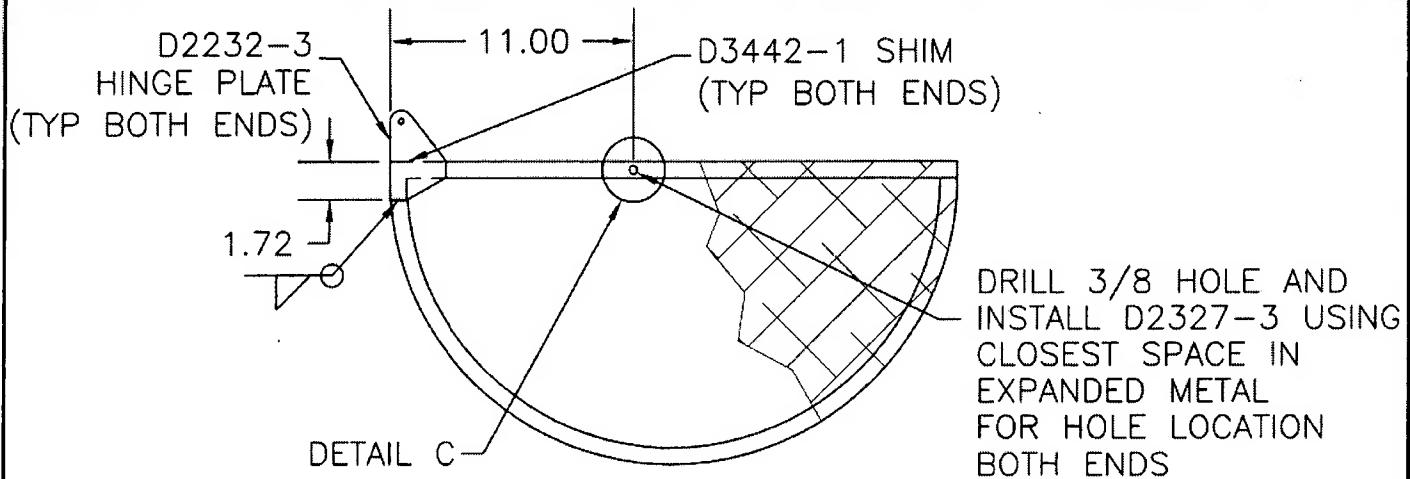
05.08.19 *MM*

#### D2221 BASKET BASE ASSEMBLY

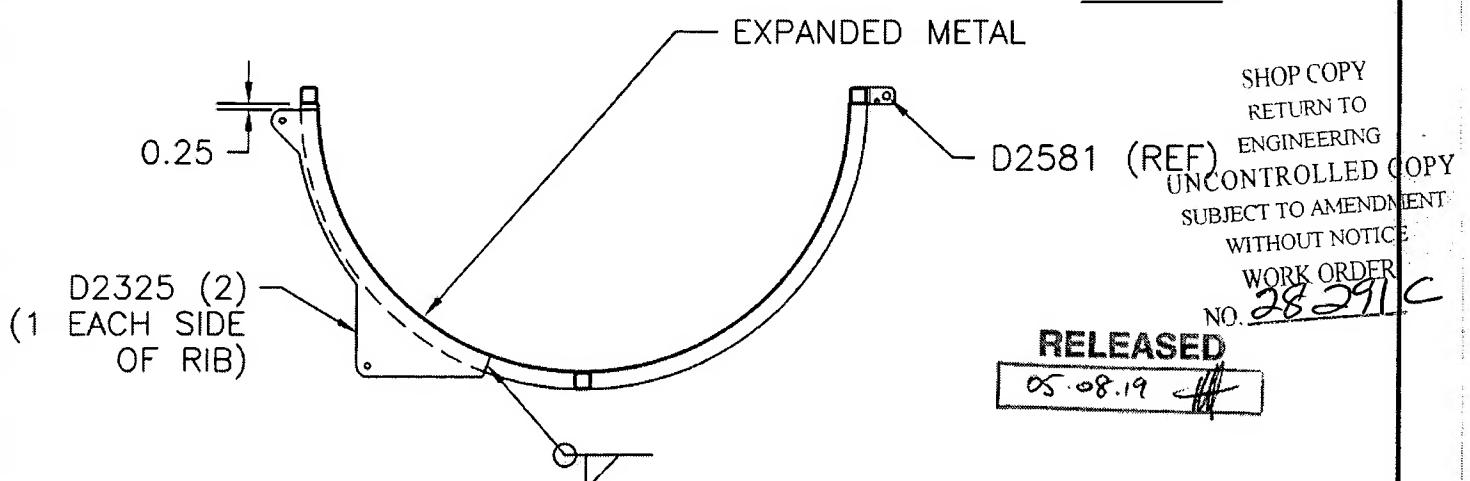
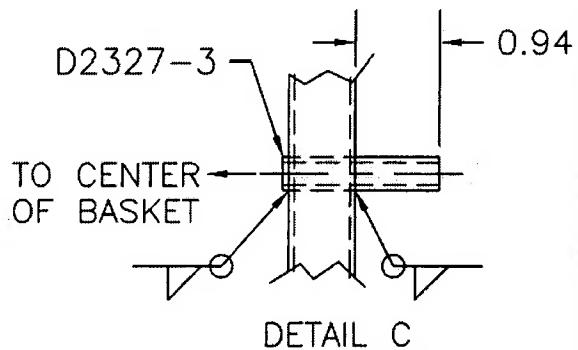
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3



DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8



### SECTION A-A SAME BOTH END RIBS



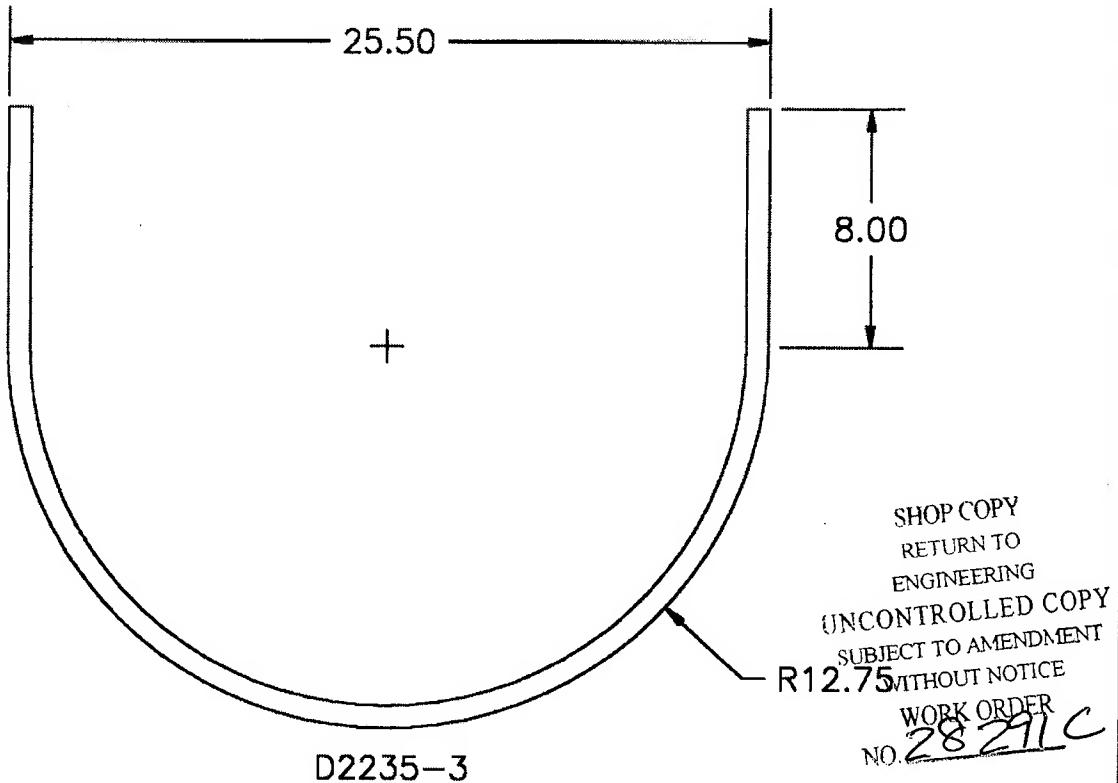
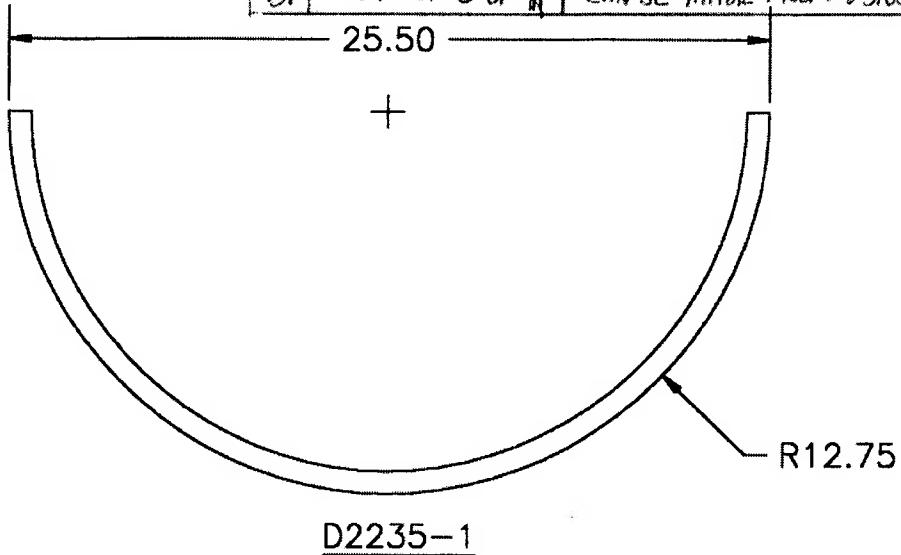
### SECTION B-B SAME BOTH CENTER RIBS

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**DART**

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>BW</i>	DRAWING NO. D2235
DATE 94:12:16		TITLE BASKET RIBS

REV. B  
SHEET 1 OF 1BI 02.08.06 *(initials)* CAN BE MADE FROM D3166-1**RELEASED**  
R 960507

CAN BE MADE FROM D3166-1 BI  
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.